

Work Order ID 50849

July 31, 2009 8:35:05 AM



Page 1

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 08/20/2009 Start Qty: 1.00
Required Date: 09/04/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:



Approvals: Process Plan: mf Date: 09-08-04 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580	Rev D								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002								
110		0.00							
	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program D2580.C on CNC Bender and Folio FT009								
	2-Cut tubes as per Dwg. D2580								

N/A

D

M 9/8/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes									
Skidtubes	Memo	0.00							
	1- Deburr ends								
	2- C'sink holes as per dwg without cutting fluid								
	3- Prepare tube for welding, remove alodine as required.								
	4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

=) 8 08/08/25

MB 09-08-25

⊕

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R ☐ ☐ Aluminum Rod *m111682**BE 09/08/25*

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R ☐ ☐ Aluminum Rod *m111682**BE 09/08/25*

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur - -5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes*3 BE 09/08/28*

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	⇒ S 08/02/09			ⓧ	✓		
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ S 08/24/09			ⓧ	✓		
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00	⇒ H 09/08/31			1	✓		

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 1:45pm OVEN TEMPERATURE: 320°F FINISH TIME: 2:15pm	0.00 0.00				1	2		
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

1112260
7 08/08/31

BR 09-09-02 0.

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 1111391 ☐ ☐
Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 1112391 ☐ ☐
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 1112106

9/10/09 09/09/02 (X)

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

2) Serial 102



220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: _____

PP

5/270

9/6/25 @ 8

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/30 J

CY 09/09/30

W/O:		WORK ORDER CHANGES					
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July 31, 2009 8:35:05 AM

Page 1

Work Order ID: 50849

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 08/20/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	7.0000	1.0000			
205 Skidtube bent detail												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

48616

1

50760

6

D2576-3RevG

Manufactured

No

140

Each

165.0000

1.0000

Step (maching detail)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

165

43504

62

46661

103

B. 50977 MB 09-08-25

1 BE 09-08-25

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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July 31, 2009 8:35:05 AM

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Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 08/20/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	412.0000	20.0000			
Crossbolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

412

43988

4

46434

4

46956

12

47797

338

48272

54

~~350927~~ ~~2~~ ~~11/21/24~~
351315 (x20) BE 9/8/25

D2855RevA

Manufactured No

200

Each

66.0000

1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP6

52

50513

52

Main Warehouse

ST

14

10360

2

35663

7

41340

1

42343

3

42806

2

50513

-1

x1 H 09/09/02

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 08/20/2009

Required Date: 09/04/2009

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A  Bolt		Purchased	No			200	Each	2,560.000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2560	
100188	246	
105057	2246	
15205	68	

XZ 41 09/09/02

AN960JD10L  Washer	Purchased	No				200	Each	6,911.000	2.0000			
--	-----------	----	--	--	--	-----	------	-----------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6911	
101291	16	
104885	153	
105793	236	
109632	1506	
110985	5000	

XZ 41 09/09/02

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Shop Packet Print

Page 3

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			200	Each	3,706.000	50.0000			

Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	3706	
105855	16	
108606	52	
111529	1638	
<u>11779</u>	2000	

AN3C4A

Purchased

No

200

Each

2,071.000

50.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	2071	
112082	121	
<u>112314</u>	1950	

X50 H/ 09/09/02

X50 H/ 09/08/02

July 31, 2009 8:35:05 AM

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AN960C10L  washer		Purchased	No			200	Each	4,591.000	50.0000			

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG 100

103585 100

Main Warehouse

ST 4491

112116 4491

D3566-13RevC

X

Manufactured

No



200

Each

47.0000

1.0000



x50 41 09/09/02

Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 47

45717 1

46889 5

47435 7

48166 18

50265 16

~~B50270~~

x1 41 09/09/02

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D3566-5RevC 	✓	Manufactured	No			200	Each	22.0000	1.0000			
Gasket												

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

B 51260

X1 M 09/09/02

ST

22

36113

1

46186

1

47318

1

48167

19

D3566-1RevC

✓

Manufactured

No

200

Each

34.0000

2.0000

Gasket

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

B 51259

X1 M 09/09/02

ST

34

46349

1

47434

2

48165

8

48557

11

50278

12

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D3564-11RevD	+	Manufactured	No			200	Each	30.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

B51256

x1

yl 09/09/09

ST

30

45823

1

47432

7

48553

12

50112

10

D3564-13RevD

+

Manufactured

No

200

Each

55.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17

35

48554

13

50270

22

Main Warehouse

ST

20

45409

3

46495

10

47867

7

x1

yl 09/09/09

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD  Wearshoe		Manufactured	No			200	Each	17.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

1351258

x1 21 09/09/09

ST

17

44659

1

45825

1

47316

4

48556

11

D3564-5RevD



Wearshoe

Manufactured No

200

Each

22.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

1351257

x1 21 09/09/09

FG

2

34806

2

Main Warehouse

FP19

12

48555

12

Main Warehouse

ST

8

45824

1

47433

1

48164

6

July 31, 2009 8:35:05 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 31, 2009 8:35:05 AM

Page 9

Work Order ID: 50849

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Start Date: 08/20/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC		Manufactured	No			200	Each	894.0000	16.0000			
												
O-Ring, 205 Skidtube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

894

27168

44

29908

850

D2594-1RevC

Manufactured

No

200

Each

700.0000

16.0000



Plug, 205 Skidtube

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

700

42221

16

42807

92

43884

87

46435

3

47251

502

X16 9/1 09/09/02

X16 9/1 09/09/02

July 31, 2009 8:35:05 AM

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. 0 SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

Handwritten: #509619
07-06-28-04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28-11

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Diagram illustrating the assembly of the D2579 Spacer. The assembly consists of a central web (D2596 WEB (REF)) and a flange (D2579 SPACER). The flange is shown with a cross-section view indicating a hole. The assembly is performed by drilling and bending the web to fit into the flange.

PERFORM DRILLING AND BENDING ASSEMBLY
 FOLLOW THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

Labels in the diagram:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF)
(TYP 50 PLACES)

5

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible]

D3560-041 ASSEMBLY DETAIL

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 D

8

P P P P P P P

REFER TO DETAIL C


D3566-1 D3566-5 D3566-1 D3566-13

D3564-11 D3564-5 D3564-9 D3564-13

AN3C4A BOLT (1)
AN560C10L WASHER (1)
(50 PLACES)

DESIGN	JJ	DRAWN BY	
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	CHECKED	APPROVED		DRAWING NO.	REV. D
				D2580	SHEET 2 OF 3
	DATE	TITLE		SCALE	
	07.02.27	205 SKIDTUBE ASSEMBLY		1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07 Dec 28

Diagram illustrating the grinding locations for the propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{8}$

Ø0.208

DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

AN3-SA BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

D2855 CAP

SEAL WITH
SIKAFLEX-241/-291

SEE NOTE ii)

0.40

Diagram of a circular component with various parts labeled:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP. 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2596 WEB
3 7
1.750 1.750
Ø0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL E
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
B.188 PITCH
38.0
91.500
190.0
(D2500-1)

(MAKE FROM D2580-1 DRILLING DETAIL)

5.985

51.340

5.338 (REF)

39.580

5.915

3.630 (REF)

0.508 (8 PLACES)

20.0

0.640

1.4

11.0

1.0

1.0

13.4

32.0 ± 1.0

1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT

1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT

V43 ASSEMBLY DETAIL

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

H

NO C'BORE NO PLUG

REFER TO DETAIL G

P

P

P

P

P

P

P

NO C'BORE NO PLUG

1.5

1.5

1.5

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13


AN3C4A BOLT (1)

AN360C10L WASHER (1)

(50 PLACES)

DESIGN	DRAWN BY	CHECKED BY
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	CHECKED	APPROVED		DRAWING NO.	REV. 0
	DATE	TITLE		SHEET 3 OF 3	SCALE
	07.02.27	205 SKIDTUBE ASSEMBLY			1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 207

**AWS D17.1.2001
QUALIFICATION TEST RECORD**

Name: Barclay Elliott
Job number: 50849
Part number: D205-624-041
Description: 205 skt tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 09.08.27

Welder [Signature] Date of Test Coupon 09.08.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld